Memo

QC

Quality Control

122460

Page 1

N900040100 Setup Start Accept Item ID: D3492-1 **Revision ID:** Plug Item Name: *60* **Cust Item ID: Start Qty: 60.00 Start Date:** 7/21/14 Req'd Qty: 60.00 *60* **Customer:** Required Date: 7/21/14 Reference: Run Start Process Plan: MLJ Date: 1407-21 Tooling: Date: Approvals: Date: Date: SPC (Y/N): Reject Reject Insp. Tool ID Tool # Plan Accept Set Up/ Operation Sequence ID/ Number Stamp Qty Oty Code **Run Hours** Description Work Center ID **Revision Nbr** Draw Nbr D3492 Ε 0.00 02 9-89 4 14 -07 -100 Hardinge CNC LATHE SMALL *100* 0.00 Hardinge Memo 1-Turn as per Folio FA633 & Dwg D3492 Hardinge CNC Lathe Small Dwg Rev: Folio Rev DAS at 1407-24 OC2- Inspect parts off machine FAI/FAIB 0.00 110 *110* 0.00 QC Memo **Quality Control** 0.00 QC8- Inspect parts - second check 120 *120*

0.00

DQA:			. Date:			•				<u> </u>			DART
			D-4			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		ork Order up	ndate only	AEROSPACE
QA Closed:			Date:							VV	ork Order up	date only	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	•			·		Rework	ıİ		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-		<u>-</u>			Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite]	Supplier	
											l c: 0	-	
Root			1		Desc	ription of work order update	ı	nitial	Acti		Sign &	M = 261 = 241 = 2	OC learnester
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design											.*		
Doc/Data	Ш										, , , , , , , , , , , , , ,		
Equip/Tooling													
Handling/Pre		ľ					1						
Material													
Operator													
Offset/Setup											_		
Process										,			
Supplier			-										
Training							İ						
Transport													
Unapproved					<u> </u>		_				<u></u>	<u> </u>	
							FA	ULT CA	TEGORY				
Landi	ng (Gear			_	General	_	1 .			1	Г	- .
		Bending			·	Bend		-	Program		Outside Dim	<u> </u>	Pressure/Forced
		Centre N	ot Conce	ntric	L	BOM/Route		Grain			Over/Under	F	Set-up
	匚	Cracks			L	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorre	-	Temperature/Cure
		Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing	Weld
	L	Cuffs				Contamination		4	tions Incomplete/U	nclear	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center	<u> </u>	Positioned V		
		Heat Trea	at			Cut Too Short	L	Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	natter			Drill Holes		Off-set		0			
		Turning S	Sequence	!		Finish		Out of	Calibration •				•
1		Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence				

Work Order ID 122460

122460

July-21-14 9:01:05 AM

Item ID: **Revision ID:** D3492-1

Plug Item Name:

7/21/14

Required Date: 7/21/14

Start Qty: 60.00 Req'd Qty: 60.00

60

Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

.

Date:

Date:

Tooling:

Accept

SPC(Y/N):

Date:

Date:

N900040100

Run

Setup Start *NC1*

Work Center ID 150

Sequence ID/

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ Run Hours 0.00

Tool # Plan Code

Accept Qty

Reject Reject **Qty**

Insp. Number Stamp

150 HandFinish

Memo

0.00

60 Hor47-28

Hand Finishing

160

170

QC

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

0.00

0.00

60

CK18-0827

Powdercoat Powder Coating

160

(Flat End Only) START TIME: OVEN TEMPERATURE:

FINISH TIME:

DAS 38

OC3- Inspect Part Finish

m128959

CAG

Quality Control

170

Memo

0.00

DQA:			Date:											TART
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only		
Manta Onda						DISPOSITION			AGAINST	DEI	PARTMENT,	PROCESS		~ .
Work Orde	-					Rework	1		Skid-tube Crosstube			Water Jet		Engineering
Part N	l۵					Scrap	1	1	Machining Small Fab	-	Pro	d. Eng. Coor.	┪	Quality
raiti					—	Use-as-is			noforming Finishing	\vdash	1	e/Packaging	ヿ	Other
NCR N	lo.					Suspected Unapproved	1	~3 ~	Large Fab Composite			Supplier	٦	
	•	_					•						_	
Root					Desc	ription of work order update	Ī	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	\Box	QC Inspector
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Equip/Tooling														
Handling/Pre														
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Supplier														
Training														
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Unapproved				<u> </u>	<u> </u>		ΓΛ	III T CA	LTEGORY		<u> </u>			
				_ 		General	FA	OLI CA	IEGONI		<u> </u>		_	
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	H	Centre No	nt Concer	atric	-	BOM/Route	-	Grain	Tobram	_	Over/Under	F-	—	Set-up
	\vdash	Cracks	ot concer	THE IC	<u> </u>	Broken/Damage/Defect		Hardwa	are		Part Incorre	F	\dashv	Temperature/Cure
	\vdash	Crimp/Kii	nk/Rinnle	/Wave	-	Burrs		4	ion Incomplete/Unqualified		Part Lost/Mi		ᅱ	Weld
		Cuffs	ing mppic	,, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		Contamination		- i '	tions Incomplete/Unclear	\vdash	Part Moved	ľ	\neg	Wrong Stock Pulled
		Crushing				Countersink	\vdash	4	gned/off center	I^{-}	Positioned V	Vrong	_	-
		Heat Trea	at			Cut Too Short		Mislabe			Power Loss/			Other
	Г	Inspectio		Tube		Drawing		Misrea				_		
		Marks/Cl	•			Drill Holes		Off-set						
		Turning S				Finish		Out of	Calibration					
		\\/a\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\				Teit/Function		Out of	Sequence					

Work Order ID 122460

122460

July-21-14 9:01:05 AM

Required Date: 7/21/14

Item ID:

D3492-1

Revision ID: Plug

Item Name: **Start Date:**

7/21/14

Start Oty: 60.00 Req'd Qty: 60.00

60

60

Date:

Accept

N900040100

Setup Start

Stop

Reject

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run Start

Stop

Reject

Otv

Number Stamp

Sequence ID/ Work Center ID

120

Operation Description

Identify as per dwg & Stock Location: H360

Run Hours

Set Up/

0.00

0.00

Accept

Qty

Insp.

Packaging Packaging

180

OC21- Final Inspection - Work Order Release

0.00

100

Quality Control

190

Memo

Memo

0.00

DQA:			Date:										DART
.			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	14/	ork Order up	vdate only	AEROSPĀCĒ 7
QA Closed:			Date:							**	ork Order up	date only	
Work Orde	er:			ı		DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
	•					Rework			Skid-tube Crosstube	Γ		Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector_
Design												i	
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup											<u> </u>		,
Process											i i		
Supplier													
Training				ŀ									
Transport					,								
Unapproved													
							FA	ULT CAT	TEGORY				
Landi	ng (Gear				General		-		_	1	<u></u>	-
		Bending				Bend		4	rogram		Outside Dim	 	Pressure/Forced
		Centre No	ot Concer	ntric	_	BOM/Route	$ldsymbol{f eta}$	Grain		<u>_</u>	Over/Under	-	Set-up
		Cracks				Broken/Damage/Defect	_	Hardwa			Part Incorre	_	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		4 .	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
		Cuffs				Contamination		_	ions Incomplete/Unclear		Part Moved	<u> </u>	Wrong Stock Pulled
		Crushing				Countersink	$ldsymbol{le}}}}}}$	-1	ned/off center	\vdash	Positioned V		-
		Heat Trea	it			Cut Too Short		Mislabe		L_	Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread					
		Marks/Ch	natter			Drill Holes	L	Off-set					
	L	Turning S	equence			Finish	<u></u>	-{	Calibration				
	1	Wave/Tw	ist in Tul	эе		Fit/Function		Out of S	Sequence				

Picklist Print

July-21-14 9:01:10 AM

Work Order ID: 122460

D3492-1

Parent Item Name: Plug

, , , **.** .

122460

D3492-1

Start Date: 7/21/14

Required Date: 7/21/14

Page 1

Start Qty: 60.00 Required Qty: 60.00

Comments:

Parent Item:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item		Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No	. ,		100	f	44.8075		AS	_	,	
*M6061T6 6061-T6 Round Bar .625"	R0 625	*		Location		Loc	Otv	Loc Code)2 -89	100	14.	07-24

DQA:		_ Date:											TRAC
		_			WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE		Louis		AEROSPACE
QA Closed:		Date:								W	ork Order up	date only	
Work Orde	ar.				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
WOIK OIGC	·'·				Rework			Skid-tube	Crosstube	Г		Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	Other
NCR N	lo	-	·	<u> </u>	Suspected Unapproved			Large Fab	Composite			Supplier	
Root				Desc	ription of work order update	1	nitial	Acti	on		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	QC Inspector
Design													
Doc/Data		1											
Equip/Tooling											İ		
Handling/Pre													
Material													
Operator													
Offset/Setup		i	i i										
Process					•								
Supplier											_	<u> </u>	
Training				İ		1							
Transport				,									
Unapproved			<u> </u>									<u> </u>	
					· · · · · · · · · · · · · · · · · · ·	FA	ULT CA	TEGORY			·-·-		
Landii	ng Gear			_	General		1				1		7
	Bending				Bend	_	•	Program		<u></u>	Outside Dim	⊢	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			<u></u>	Over/Under	 	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa			<u> </u>	Part Incorre	⊢	Temperature/Cure
	Crimp/H	(ink/Ripple	e/Wave		Burrs		1 '	ion Incomplete/Un	•		Part Lost/M	issing	Weld
	Cuffs			<u> </u>	Contamination	<u> </u>	4	tions Incomplete/U	Inclear	\vdash	Part Moved	L	Wrong Stock Pulled
	Crushin			igspace	Countersink	<u>_</u>	1	gned/off center		L	Positioned V		ا ا
	Heat Tr				Cut Too Short		Mislab				Power Loss/	Surge	Other
		on Strip ir	Tube	_	Drawing		Misrea						
	Marks/				Drill Holes	L	Off-set						
		Sequence			Finish	L	4	Calibration					
	Wave/1	wist in Tu	be		Fit/Function		Out of	Sequence					

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DART AEROSPACE LTD	Work Order:	122460
DART AEROSPACE LTD		
D. Jakione Diug	Part Number:	D3492-1
Description: Plug		D
Inspection Dwg: D3492 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Actual			Method of	0
Tolerance	1	Accept	Reject	Inspection	Comments
+/-0.005					
+/-0.005	0.059				
+/-0 010	0.393				
+/-0.010					
+0.000/-0.002	0.089				
+/-0.010	0.500				
+0.000/-0.002	0.049				
+/-0.010	0.050				
					·
		+			
	+/-0.005 +/-0.005 +/-0.010 +/-0.010 +0.000/-0.002 +/-0.010 +0.000/-0.002	Tolerance +/-0.005 +/-0.005 -/-0.010 +/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.002 -/-0.010 -/-0.002 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010	Tolerance Dimension	Tolerance Dimension Accept Reject +/-0.005	Tolerance Dimension Accept Reject Inspection +/-0.005

DAS				
Measured by: 02	Audited by:	MH	Preliminary Approval:	
9-89. /	Date	14/07/25	Date:	
Date: 14-07-24	Date.	19/0//25		

			Revised by	Approved
Rev	Date	Change	KJ/JLM	
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
В	06.10.16	Ø0.625 was Ø0.500	KJ/EC/DD	
	07.11.23	Tolerances revised		
D	08.06.19	0.050 x 20° dimension added	KJ/DD	
	11.07.26	Dimensions updated per Dwg Rev D	KJ /A-	+ +1
<u>-</u>		Dwg Rev updated	KJ 🛠	<i>[A</i> 60
<u> </u>	14.01.21	Dwy Nev updated	1)	

DQA:			Date:			•			_					
						WORK ORDER NON	-CC	ONFO	RMANCE / UP				A E R	OSPACE
QA Closed:			Date:							W	ork Order up	date only		·
Work Orde	. r.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
WOIK OIGE	-					Rework	ıl		Skid-tube	Crosstube	1	Water Jet	Engineer	ring
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Qua	
	•	•••				Use-as-is			noforming	Finishing	-	e/Packaging	Ot	her
NCR N	No.					Suspected Unapproved			Large Fab	Composite]	Supplier		
							•							***
Root		-			Desc	ription of work order update	1	Initial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Ins	pector
Design														
Doc/Data													ļ	
Equip/Tooling	Щ													
Handling/Pre	Ш		1											
Material							l							
Operator							ļ							
Offset/Setup														
Process	Ш													
Supplier	Ш													
Training	Ш													
Transport	Щ													
Unapproved			<u> </u>	<u> </u>			1		<u> </u>	_				
				1817			FA	ULT CA	TEGORY		***			-
Landi						General		7	_		7	. г		
		Bending			<u> </u>	Bend	\vdash	4	Program	<u> </u>	Outside Dim	⊢	Pressure/Fo	orcea
	Ш	Centre N	ot Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain		<u> </u>	Over/Under	F	Set-up	
	Ш	Cracks				Broken/Damage/Defect		Hardwa			Part Incorre	<u> </u>	Temperatu	re/Cure
	_	Crimp/Ki	nk/Ripple	:/Wave		Burrs	\vdash	4 `	ion Incomplete/Un	_	Part Lost/M	ssing	Weld	-1. D. II1
		Cuffs			<u> </u>	Contamination	-	⊣	tions Incomplete/U	nclear	Part Moved	L	Wrong Stoo	ck Pulled
	\sqsubseteq	Crushing				Countersink		4	gned/off center	<u> </u>	Positioned V		704	
	-	Heat Trea			\vdash	Cut Too Short	<u>_</u>	Mislab		<u></u>	Power Loss/	Surge	Other	
	-	Inspectio	-	Tube	\vdash	Drawing	\vdash	Misrea						
	-	Marks/Cl			\perp	Drill Holes	\vdash	Off-set						· · · · · · · · · · · · · · · · · · ·
	-	Turning S				Finish	\vdash	-1	Calibration			-		
1	1	Wave/Tw	vist in Tuk	oe e		Fit/Function	1	1Out of	Sequence					

-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

		<u> </u>								
╛	DESCRIPTION	PART NUMBER	QTY -055	QTY -053	QTY -051	QTY -049	QTY -047	QTY -045	QTY -043	QTY -041
_	PLUG ASSEMBLY	D3492-041						0.70	-043	X
	PLUG ASSEMBLY	D3492-043							X	
	PLUG ASSEMBLY	D3492-045						х		
┙、	PLUG ASSEMBLY	D3492-047					X	<u> </u>		├
	PLUG ASSEMBLY	D3492-049				х	<u> </u>		-	
_	PLUG ASSEMBLY	D3492-051	-		X					
_ ^	PLUG ASSEMBLY	D3492-053		х			 	-		
[Æ	PLUG ASSEMBLY	D3492-055	х	_	_			_		
_								_		
	PLUG	D3492-1						 	-	1
_	PLUG	D3492-3							1	<u>-</u>
_	PLUG	D3492-5					-	1	<u> </u>	
	PLUG	D3492-7					1		 	<u> </u>
	PLUG	D3492-9	1			1	 	+ -	 	-
	PLUG	D3492-11			1		<u> </u>	<u> </u>		<u> </u>
^_	PLUG	D3492-13		1			 			
Æ	PLUG	D3492-15	1					 	-	
	O-RING	NAS1611-005								
-	O-RING		<u> </u>					1	<u> </u>	
	O-RING	NAS1611-007	ļ	<u> </u>			1		1	
		NAS1611-010			L	1		1	Γ	1
	O-RING	NAS1611-012		1		l	1	1		
	O-RING	NAS1611-013		<u> </u>	↓				1	
	O-RING	NAS1611-015	1		1				T	
	O-RING	NAS1611-016		1		1	+	+	+	<u></u>

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

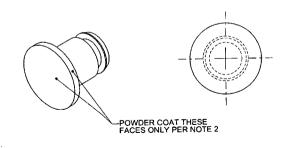
SHOP COPY RETURNTO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 122460 MLJ

REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	PH	06.01.04
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
Ε	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN AP DRAWING NO. D3492 REV. E CHECKED SHEET 1 OF 2 MFG. APPR. SCALE TITLE APPROVED DE APPR. COPYRIGHT © 2007 BY DART AEROSPACE LTD DATE 13.08.08

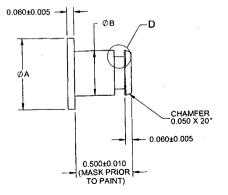
DQA:			Date:			DART								
						WORK ORDER NON	-CC	ONFO	RMANCE / UF					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Order:			DISPOSITION		AGAINST DEPARTMENT/PROCESS									
work order.				Rework Skid-tube				Crosstube		Engineering				
Part N	n					Scrap	1		Machining	Small Fab	Pro	Water Jet d. Eng. Coor.		Quality
1 41010	· -					Use-as-is		Thermoforming Finishin						Other
NCR No.						Suspected Unapproved	1		Large Fab	Composite				
Root	_		[]		Desc	ription of work order update		Initial	Acti	ion	Sign &			<u>. </u>
Cause	ĺ	Date Step Qty		Desc	•		nief Eng		Description		Verification	n	QC Inspector	
Design	+	Date	эсер	Qty		or non comormance	-	iici ziig			Date			
Doc/Data	┪													
Equip/Tooling	┪													
Handling/Pre														
Material	ヿ													
Operator	目													
Offset/Setup														
Process														
Supplier														
Training														
Transport			ŀ				İ							
Unapproved											ļ			
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Landin	ıg G	ear			_	General		n .		_	7			
		Bending				Bend	<u> </u>	-	rogram	Outside Dimensions		\vdash	Pressure/Forced	
	_	Centre Not Concentric				BOM/Route		Grain			Over/Under tolerance			Set-up
	-	Cracks				Broken/Damage/Defect	<u></u>	Hardware			Part Incorrect			Temperature/Cure
	$\overline{}$	Crimp/Kink/Ripple/Wave				Burrs	-	Inspection Incomplete/Unquali		· —	Part Lost/Missing		Н	Weld
<u> </u>	_	Cuffs			<u> </u>	Contamination	-	Instructions Incomplete/Unclear			Part Moved Wrong Stock			
ļ ļ	_	Crushing				Countersink	<u> </u>	4 -	ned/off center	\vdash	Positioned Wrong			Other
-	-	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabeled			Power Loss/	Surge	Ш	Other
	_	Inspection Strip in Tube				Drawing	\vdash	Misread						
\	Marks/Chatter					Drill Holes	\vdash	Off-set				· · · · · · · · · · · · · · · · · · ·		
	Turning Sequence Wave/Twist in Tube					Finish Fit/Function	\vdash	4	Calibration					
1	- 1	wave/Tw	ust in Tuk	эe	- 1	Trit/ Fullction	1	TOUL OF 3	Sequence					

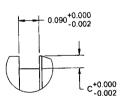
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DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	Α	В	C	MATERIAL SPEC				
D3492-1	0.625	0.394	0.050	M6061T6R0.625				
D3492-3	0.750	0.582	0.045	M6061T6R0.750				
D3492-5	0.375	0.188	0.045	M6061T6R0.375				
D3492-7	0.500	0.270	0.045	M6061T6R0.500				
D3492-9	0.938	0.750	0.045	M6061T6R1.000				
D3492-11	0.850	0.664	0.045	M6061T6R0.875				
D3492-13	0.750	0.510	0.045	M6061T6R0.750				
D3492-15	0.850	0.640	0.050	M6061T6R0.875				

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-220/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHAPE PEGGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DART AEROSPACE LTD DESIGN PH HAWKESBURY, ONTARIO, CANADA ΑP DRAWN DRAWING NO. REV. E CHECKED D3492 SHEET 2 OF 2 MFG. APPR. SCALE TITLE APPROVED PLUG 4:1 DE APPR. COPYRIGHT @ 2007 BY DART AEROSPACE LTD

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DQA:		_ Date:			TAART										
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only AEROSPA										
					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Order	:				Powerk	1		Skid-tube Crosstube	Engineering						
Part No)				Rework Scrap Use-as-is			Machining Small Fab			Water Jet d. Eng. Coor. e/Packaging	Quality Other			
NCR No)				Suspected Unapproved						Supplier				
Root				Desc	ription of work order update	li	nitial	Action	Sig	gn &					
Cause	Date Step Qty			or non-conformance		nief Eng Description			Date Verific		tion QC Inspector				
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre									1						
Material	_														
Operator												,			
Offset/Setup															
Process															
Supplier															
Training	_														
Transport		ļ		,											
Unapproved]													
						FAL	JLT CAT	TEGORY							
Landing	g Gear				General	_			_		_				
	Bending				Bend	Ш	Folio/P	Program	Outs	ide Dim	ensions	Pressure/Forced			
	Centre Not Concentric				BOM/Route		Grain		Over	/Under	tolerance	Set-up			
	Cracks				Broken/Damage/Defect		Hardwa	are	Part	Incorre	cí _	Temperature/Cure			
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified	Part	Lost/Mi	ssing	Weld			
	Cuffs				Contamination		Instructions Incomplete/Unclear Part Moved			Moved		Wrong Stock Pulled			
Ī	Crushing				Countersink		Misalig	gned/off center		tioned V	_	_			
	Heat Treat				Cut Too Short		Mislabe	eled	Pow	er Loss/	Surge	Other			
	Inspection Strip in Tube				Drawing		Misread	d							
	Marks/C	hatter			Drill Holes		Off-set								
	Turning Sequence				Finish		Out of	Calibration							
	□ _{Wave/Tv}	vist in Tul	be		Fit/Function	Out of Sequence									

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